AMENDMENTS TO THE SPECIFICATION

Please replace paragraph 40 with the following paragraph rewritten in amendment format:

As previously discussed, the present invention is not limited to the spiral shape; in alternate embodiments, other tool path algorithms keeping uniform exposure for varied shapes can be used. Also, V_{max} can be decreased in various ways between successive layers to achieve a desired contour in a finished workpiece. The vertical cross section containing the axis of the hole determines how the $V_{max}(i)$ is progressed where i is the number of steps for reducing the V_{max}. A linear function of $V_{max}(i + 1) = V_{max}\underline{(i) - \Delta V_{max}}$ results in a constant taper with fixed taper angle. Another function of $V_{max}(i + 1) = V_{max}(i) - (\Delta V_{max} * i)$ makes the taper <u>angle less and less steep as radius is reduced</u> ~~progressively steeper~~. On the other hand, $V_{max}(i + 1) = V_{max}(i) - (\Delta V_{max} / i)$ makes the taper angle <u>progressively steeper</u> ~~less and less steep as radius is reduced~~. In general, the Vmax(i) needs to be determined by the cross section (or shape) specification.